

TECHNICAL BULLETIN

FILM SUPPORTED TAPE

PRODUCT:	4380M Double-Coated Polyester Film			
PRIMARY USE:	Exposed side forms an excellent bond to a variety of ether, ester and low perm urethane foams. The liner side adhesive is designed to adhere to low-energy surfaces including mica-filled polypropylene. Engineered to meet automotive specifications			
DESCRIPTION:	The product is constructed with a high tack, heat resistant rubber liner side adhesive and a high heat resistant acrylic adhesive on the exposed side of a 0.5 mil polyester film. The exposed side adhesive contains a biostatic additive, which aids in meeting the requirements for product that are resistant to microbial growth.			
LINER:	12PT Natural poly-coated Kraft			
TYPICAL PHYSICAL PROPERTIES:	Thickness	Carrier	0.5 mils	
		Adhesive Exposed Side (nominal)	1.9 mils	
		Adhesive Liner Side (nominal)	1.6 mils	
		Liner (nominal)	11.3 mils	
	Peel Adhesion	PSTC #101; backed with 1 mil polyester <i>24 Hour Dwell:</i>		
		Exposed Side		50 oz/inch
		Liner Side		94 oz/inch
		PSTC #101; backed with 2 mil dead soft aluminum foil <i>24 Hour Dwell:</i>		
		Exposed Side		120 oz/inch
		Liner Side		160 oz/inch
	Shear Adhesion	NOTE: Peel tests are performed as per PSTC #101, which states one minute maximum dwell time. In general, for acrylic adhesives, longer residence time yields much higher peel values.		
		PSTC #107; Modified, 1000 gm/sq. in. @ 72° F. One minute maximum dwell:		
		Exposed Side		7 days
	Liner Side		3 days	

ADCHEM CORPORATION

1852 Old Country Road
Riverhead, NY 11901
P: 631-727-6000

www.adchem.com

Data presented are typical properties taken from a limited number of production runs and should not be used for specification purposes. Adchem Corporation makes no warranty, expressed or implied, and specifically disclaims and disavows any implied warranty of merchantability and of fitness for a particular purpose. Accordingly, all Adchem products are sold with the understanding that purchasers will be solely responsible for determining the suitability of the materials for any purpose.

TECHNICAL BULLETIN

4380M Double-Coated Polyester Film

PRODUCT FEATURES:	<ul style="list-style-type: none"> • Excellent adhesion to a broad spectrum of foam substrates. • High heat resistance. • Easy release 12PT excellent for kiss cutting.
AUTOMOTIVE SPECIFICATIONS:	<p>Chrysler PF-10770 (NC) GM3622M (11/93) Type IV Cycle E GM3607M (12/97) Type I GMW16443 Type 2 Ford ESA-M11P19-A (1/79) Ford ESB-M3G76-B2 (2005-SEP-26) Ford ESB-M11P8-A (11/10/78) Ford ESH-M11P19-B (3/93) Ford WSF-M11P8-A2 (1/92) Delphi Automotive SD2-324 4.3.4 High Temperature</p> <p>NOTE: For certain specifications, Individual reports containing A2LA accredited data may be provided on request.</p>
SERVICE TEMPERATURE:	<p>30°F to 180°F</p> <p>NOTE: This information is provided as a means to help characterize the adhesive's temperature resistance. Note that this data is based on limited testing and under no load. The practical service temperature of this or any adhesive system is dependent on many variables including the substrates being bonded, environmental conditions, and the loading and method of application. The purchaser is responsible for determining the suitability of this or any product for their particular purpose and process. The recommended application temperature is 68°F to 100°F.</p>
NOTES:	<p>The use of heat and pressure will help to increase the initial bond of the product to the substrate. Testing is recommended prior to laminating to any material that contains migrating plasticizers.</p>
RELATED ADCHEM PRODUCTS:	<p>Other high performance acrylic/rubber products include:</p> <p>4377M – 1.4-mils liner side & 1.3-mils exposed side 4352M – Liner side engineered for Nylon 4351M – 1.5-mils both liner & exposed side.</p>
SHELF LIFE:	<p>One year from date of shipment when stored under cool, dry conditions.</p>

Rev. 04.04.14

ADCHEM CORPORATION

1852 Old Country Road
Riverhead, NY 11901
P: 631-727-6000

www.adchem.com

Data presented are typical properties taken from a limited number of production runs and should not be used for specification purposes. Adchem Corporation makes no warranty, expressed or implied, and specifically disclaims and disavows any implied warranty of merchantability and of fitness for a particular purpose. Accordingly, all Adchem products are sold with the understanding that purchasers will be solely responsible for determining the suitability of the materials for any purpose.